

Work Order ID 122984

Tuesday, July 29, 2014 2:27:33 PM

122984

Page 1

Item ID: D3119-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover Assembly
Start Date: 8/22/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/22/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: J.A Date: 14/07/29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3119	Rev B								

100		0.00							
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100 PURCHASING CH 14/08/27 2

Purchasing Memo 0.00

Purchasing Issue P/O: 25354

Manufacture D3119-042 Cover Assembly as per Dwg D3119 (2x D3119-3 window)
Supplier: Delastek

Material: Cream Kydex 100, 0.060 thick
Material release note required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
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110 CL 11/14/18 2

Packaging Memo 0.00

Packaging Ensure Material Release Note is attached

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Required Date: 8/22/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120						(2)			
QC	Memo	0.00							
Quality Control									NOV 2 0 2014
130	Identify as per dwg & Stock Location: <i>CA</i>	0.00							
130						21			DAS 26 9-89
Packaging	Memo	0.00							NOV 2 1 2014
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									14/11/24 <i>JD</i>
QC	Memo	0.00							
Quality Control									

AR4-11-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Tuesday, July 29, 2014 2:27:33 PM

Page 1

122984

D3119-042

Required Date: 8/22/14

Required Qty: 2.00

Comments: IPP: A03.02.24New IssueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-042P		Purchased	No			100	Each	0.0000	1	2			

D3119-042P

Cover Assembly

24/11/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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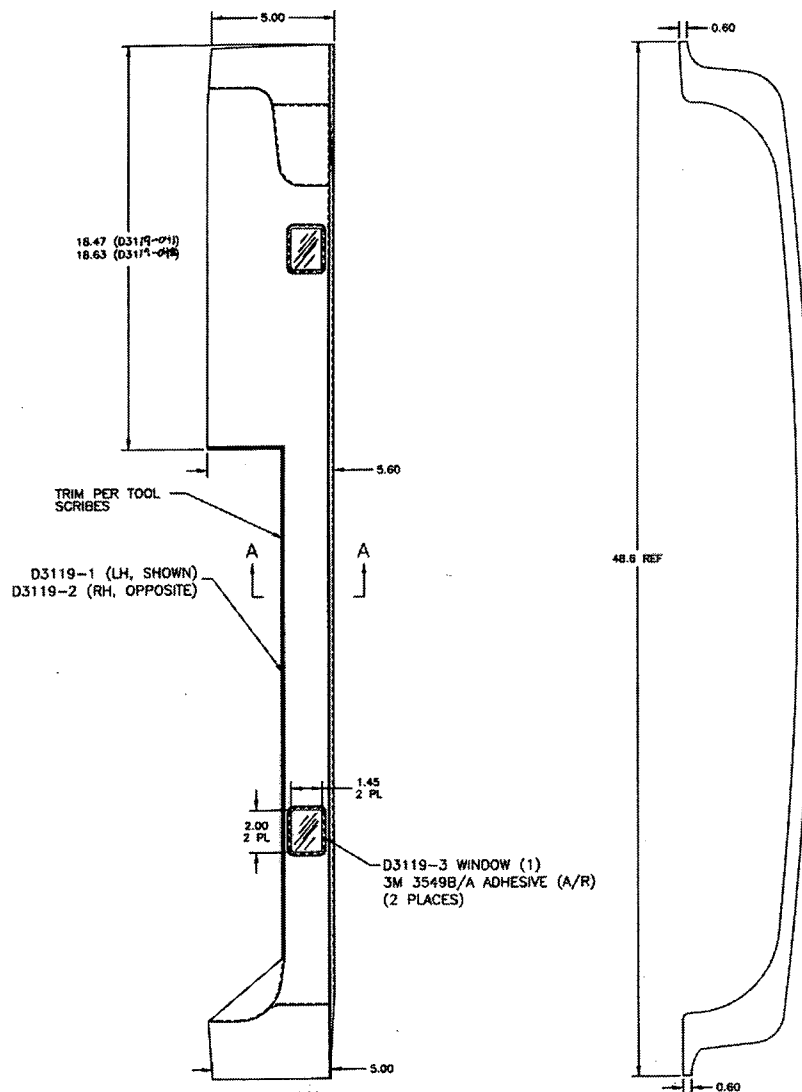
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Doc/Data									
Equip/Tooling									
Handling/Pre									
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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

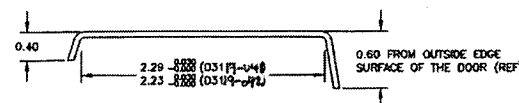
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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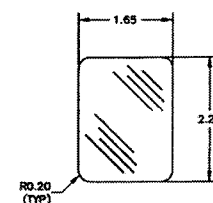
RELEASED
04.11.23



D3119-041 COVER ASSEMBLY, LH
(SHOWN, REPLACES PREMIER P/N B30-23000-29)
D3119-042 COVER ASSEMBLY, RH
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)



SECTION A-A



D3119-3 WINDOW

D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)

- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)

- 5) MATERIAL: LEXAN, 0.060 THICK

GENERAL NOTES

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

J.A. 14107129

122984

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B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
		REV. B SHEET 1 OF 1 NTS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25554

Purchase Order Date 8/27/2014

PO Print Date 8/27/2014

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100
GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 533 5788
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

FAKED

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3119-041P AS PER DWG D3119 REV. B B123748 MATERIAL: CREAM KYDEX 100, 0.060" THICK	Cover Assembly	9/19/2014 Yes 9/19/2014 10/27		4.00 Each ✓	\$112.62	\$450.48
Line Total:							\$450.48
2	D3119-042P AS PER DWG D3119 REV. B B122984 MATERIAL: CREAM KYDEX 100, 0.060" THICK	Cover Assembly	9/19/2014 Yes 9/19/2014 10/27		2.00 Each ✓	\$112.62	\$225.24
Line Total:							\$225.24

021411118

Note:

8/27/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25554**

Purchase Order Date 8/27/2014

PO Print Date 8/27/2014

Page Number 2 of 2

Order From :

VU-DEL003

Ship To : DART AEROSPACE LTD

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

3	71401-45	PROCUREMENT QUALITY CLAUSES	9/19/2014	1.00	\$0.00	\$0.00
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No

9/19/2014

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A016 personnel qualification

A025 certification of conformance

A040 notification of quality escape

A041 quality management

A042 dart notification by supplier

A043 retention of quality documents

Line Total: \$0.00

PO Total: \$675.72

CX

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 8/27/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	58798
Customer No.	DART US

Bill To


DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
17-11-2014	08-09-2014	24973	Chantal Lavoie	PO25554	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Melody Shapcott, ext. 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
4	0	4	DKC135-0001	Line #1 D3119-041 Cover Assy B123748 U of M: Chaque Dwg Rév.: B Lot # 65365 1 65456 3	
2	0	2	DKC135-0002	Line #2 D3119-042 Cover Assy B122984 ✓ U of M: Chaque Dwg Rév.: B C21411118 Lot # 65366 ✓ 2 DOCUMENT INCLUS 	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-10-30 15:50:21
Utilisateur: Véronique Bouchard

Feuille de Procédé

ASAP

Client : DART US DART AEROSPACE
Numéro Job : 65366
Numéro : 4137
Numéro B.A. :
Cette fois : 2014-10-30 No. :
Prsht Rev. : NC
Prem. fois : Type :
Job précédente : 29238



Nom Dessin : COVER ASSY
Numéro Article : DKC135-0002
Numéro Dessin : D3119
Projet Numéro : DKC135
Révision dessin : B
Matériel : Kydex 100 beige .060" Thk
Date Dûe : 2014-11-06 Qté: 6 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Dart Aerospace: D3119-042
N° de pièce Delastek Aeronautique: DKA359-0006
N° de pièce Delastek Composites: DKC135-0002

Process Sheet Rév.: 02 Modifier dimension du matériel
dans la séq. Thermoformage.

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AMB0208 Kydex 100 cream 0.060"thick # 72005

Comment Qty.: 0.36 FEUILLE(s)/Unit Total : 2.16 FEUILLE(s)
Kydex 100 cream 0.060"thick N° de Lot : 4846010AA

2.0 THERMOFORMAGE Thermoformage / Découpe primaire



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Monter le set-up du moule de thermoformage N° DKG 359-505 sur le thermoformeur 4' x 8' selon IG 0088.

Tailler le matériel selon les dimensions requises : 24" x 68" x .060" Thk.

Thermoformer la pièce B30-23000-220 selon IG 0089.



Quantité: 6 Date: 31/10/14 Sceau:

3.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe primaire sur la scie à ruban.

Faire le trimage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Ébavurer.

Date: Jeudi, 2014-10-30 15:50:21

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: COVER ASSY

Numéro Job: 65366

Numéro DKC135-0002

Numéro Job:



Séq.:

Machine ou Opération:



Description:

Quantité: 6 Date: 10-11-14 Sceau:

4.0 AMB0209

Lexan 9034 transparent 0.060" thickness

Comment Qty.: 0.000 POUCE CAR(s)/Unit Total: 0.000 POUCE CAR(s)

Lexan 9034 0.060" thickness

N° de Lot: 4774 410 AA

5.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Sur le banc de scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" aux quatre coins.

Ébavurer.

Quantité: 6 Date: 11-11-14 Sceau:



6.0

AAC0562

3549 B/A adhesive kit 2oz.

Comment Qty.: 0.00 UNITE(s)/Unit Total: 0.00 UNITE(s)

3549 B/A adhesive kit 2oz.

N° de Lot: 4844010 AA

7.0

PRÉPARATION.

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.

Date: 6 Sceau: 11-11-14



8.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assembler les deux B30-23000-221 Window sur le B30-23000-220 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.

Quantité: 6 Date: 11-11-14 Sceau:



9.0

IDENTIFICATION

Identification des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'identification : N° de pièce : D3119-042

Date de fabrication : 14-11-14

N° de Work Order: _____

Sceau d'inspection

Date: Jeudi, 2014-10-30 15:50:21
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 65366

Nom Dessin: COVER ASSY
Numéro DKC135-0002

Numéro Job:



Séq.:

Machine ou Opération:

Description:

Quantité: 6 Date: 14-11-14 Sceau: 14

10.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection par le département de la qualité selon le dessin

Quantité: 6 Date: 14-11-14 Sceau: 14

11.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Emballer et entreposer selon IG 0057.

Quantité: 6 Date: 14-11-14 Sceau: 14